

**Work Order ID 71744**

Monday, July 11, 2011 9:07:41 AM

Page 1

Item ID: D3838-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 7/11/2011 Start Qty: 2.00

Required Date: 7/15/2011 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3838

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-1 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: 1114649

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: 111649

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary






PMB 11/07/20 (2)  
CPL 11-02-20



**Work Order ID 71744**






Monday, July 11, 2011 9:07:41 AM



Page 2

Item ID: D3838-041 Accept  Setup Start   
Revision ID: Stop   
Item Name: Rib Assembly (Basket Lid, LH)  
Start Date: 7/11/2011 Start Qty: 2.00  Cust Item ID:  
Required Date: 7/15/2011 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00					11.07.20		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00					11 07 21	2	
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u>  Memo	0.00  0.00				SAD	11-07-21	2	

**Work Order ID 71744**

Page 3

Monday, July 11, 2011 9:07:41 AM

Item ID: D3838-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 7/11/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/22 [Signature]  
ME  
11-07-21

# Picklist Print

Monday, July 11, 2011 9:07:47 AM

Page 1

Work Order ID: 71744



Parent Item: D3838-041



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 7/11/2011

Required Date: 7/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1 		Manufactured	No				Each	215.0000		2			
Bushing													

Location	Loc Qty	Loc Code
----------	---------	----------

WA	200	
69202	200	
WA005	15	
66489	2	
66870	13	

2 PAB 11/07/20

M304TS0.750W.065

Purchased

No

100

f

697.9792

1.0317

2.172



304 SQ Tube .75x.75x.065W

Location	Loc Qty	Loc Code
----------	---------	----------

MAT018	91.83716	
117598	14.13846	
117636	77.6987	
WA	500	
118181	500	
WA007	106.1419906	
116267	99.549272	
116763	6.5927186	

2.172 PMB 11/07/20

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

**D3838-041 RIB ASSY (BASKET LID, LH)**


**D3838-042 RIB ASSY (BASKET LID, RH)**

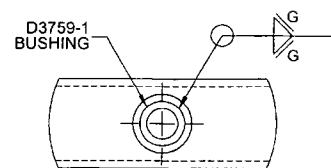
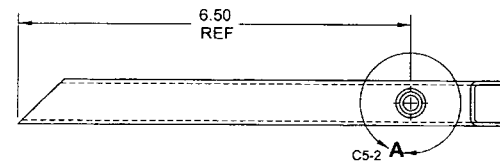
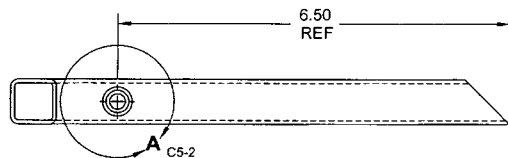
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71744

*2011-07-11*

**RELEASED**  
*08/11/11*

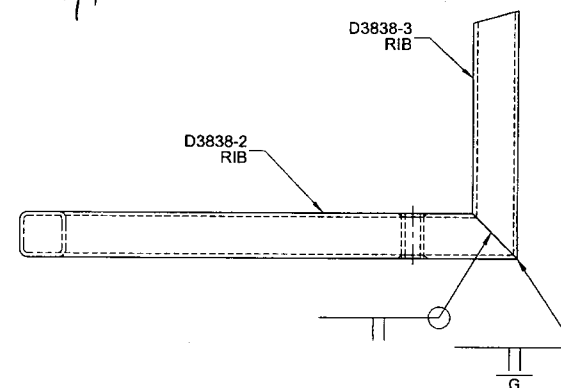
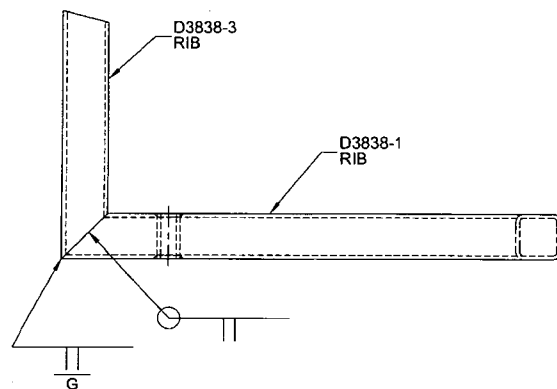
- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.54 lbs

A	NEW ISSUE		MB	08.10.08
REV.	DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3838	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		<b>RIB ASSY (BASKET LID)</b>		NTS
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**DETAIL A**  
D2-2  
D7-2 SCALE 2X

71744



**D3838-041 RIB ASSY (BASKET LID, LH)**

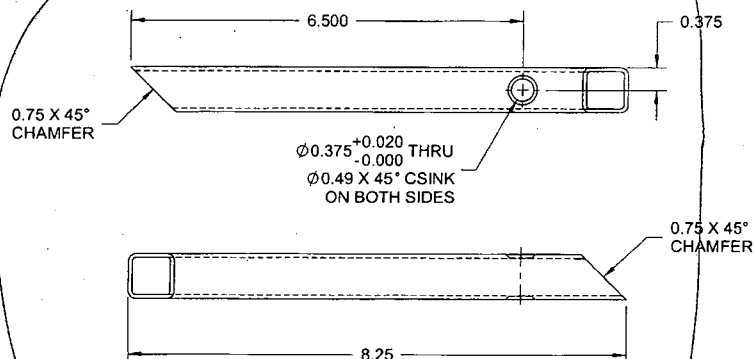
**D3838-042 RIB ASSY (BASKET LID, LH)**

**RELEASED**  
08/10/08

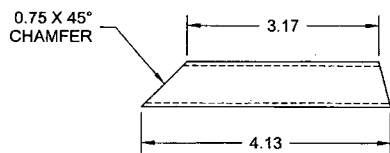
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3838</b>	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		<b>RIB ASSY (BASKET LID)</b>	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

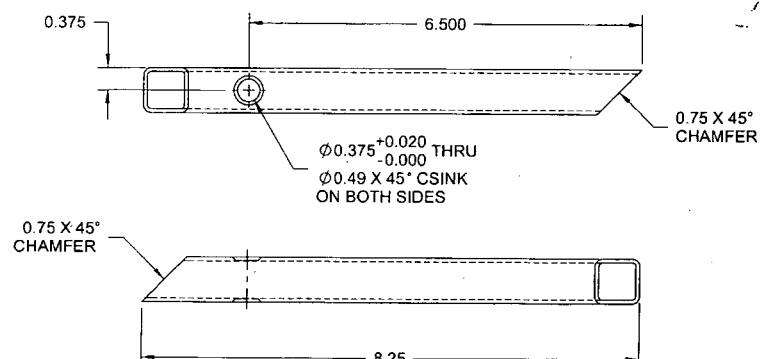
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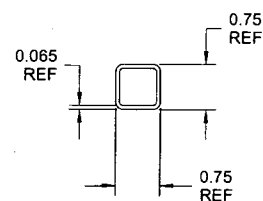
**D3838-1 RIB**



**D3838-3 RIB**



**D3838-2 RIB**



**TYPICAL SECTION VIEW**

11744

**RELEASED**  
24/11/2011

A

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D3836-2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3838</b>	REV. A
MFG. APPR.		TITLE <b>RIB ASSY (BASKET LID)</b>	SHEET 3 OF 3
APPROVED		SCALE	NTS
DE APPR.		* COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1